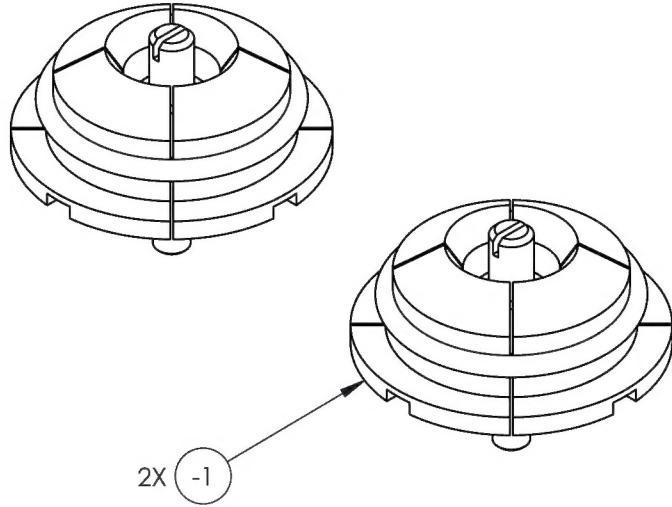


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION	5/24/2016	DPD	JAG



NOTE:  
REF. EUROCOPTER T/N: 105-41069W3.

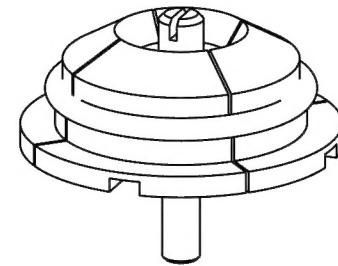
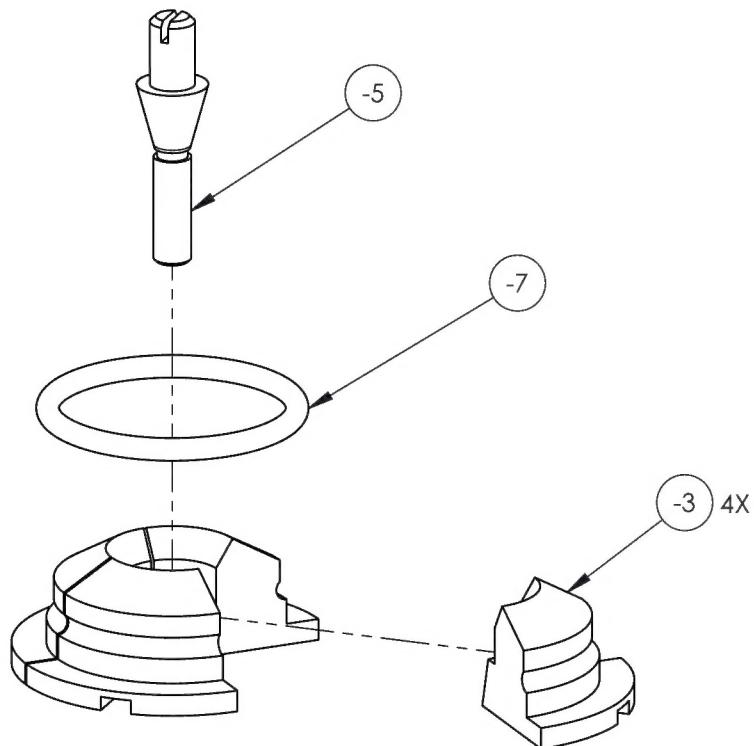


TITLE		REV	
DWG NO.		1	
RBE105-41069W3			
MAT'L		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH		.XX ± .01 ANGLES ± 5°	
SPEC		X ± .1 SURFACES = 125 ✓	
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR: LINDSAY		USED ON MODEL	
APPROVED: GILBERT		EC145	
SCALE 1:1		DATE 1/19/2016	
ASSY -1		SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
					STAKING TOOL ASSEMBLY			2
	X		-1	2	STAKING TOOL ASSEMBLY			2
					STAKING INSERT	4140/4142		3
	4		-3		STAKING INSERT	4140/4142		3
					POSITIONING SCREW	4140/4142		4
	1		-5		POSITIONING SCREW	4140/4142		4
					O-RING	BUNA-N	Ø3mm X 30mm I.D. (MCMASTER-CARR #1174N608)	2
	ASSY -1							

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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STAKING TOOL ASSEMBLY

DART AEROSPACE	
TITLE	
STAKING TOOL	
DWG NO. RBE105-41069W3-1	
REV	1
MAT'L	
HEAT	
TREAT	
FINISH	
SPEC	
DRAWN BY: DUERFELDT	
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE	1:1
DATE	1/19/2016
SHEET 2 OF 4	

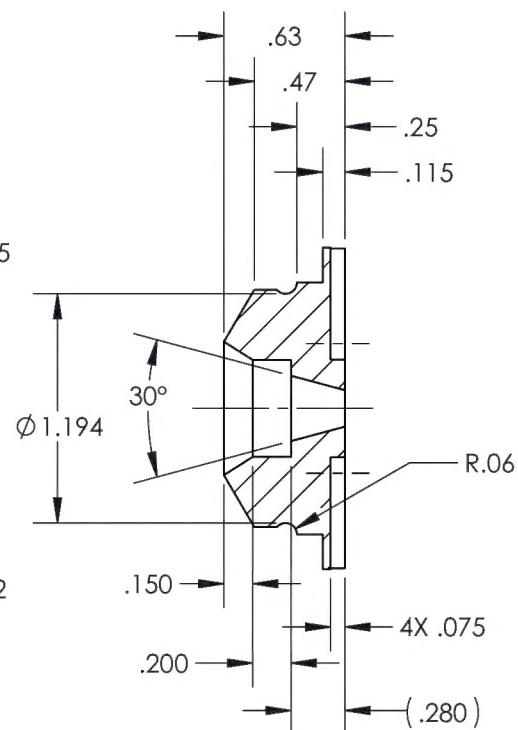
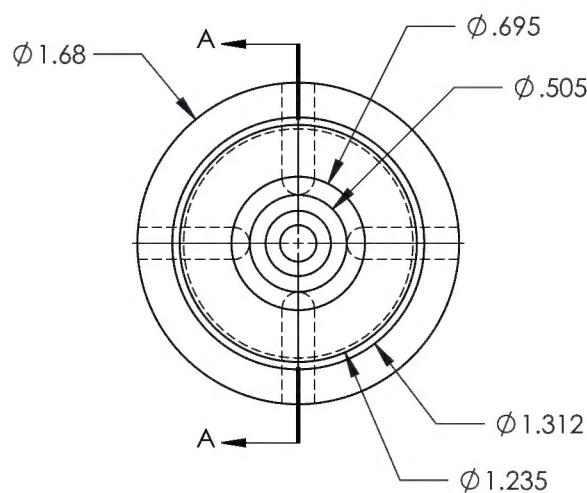
UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
.XXX ± .005 FRACTIONS ± 1/8  
.XX ± .01 ANGLES ± 5°  
X ± .1 SURFACES = 125 ✓

1. BREAK ALL SHARP EDGES  
.015 x 45° OR .015R  
2. DIMENSIONAL LIMITS APPLY  
AFTER PLATING  
3. INTERPRET DIM AND TOL PER  
ASME Y14.5M-2009

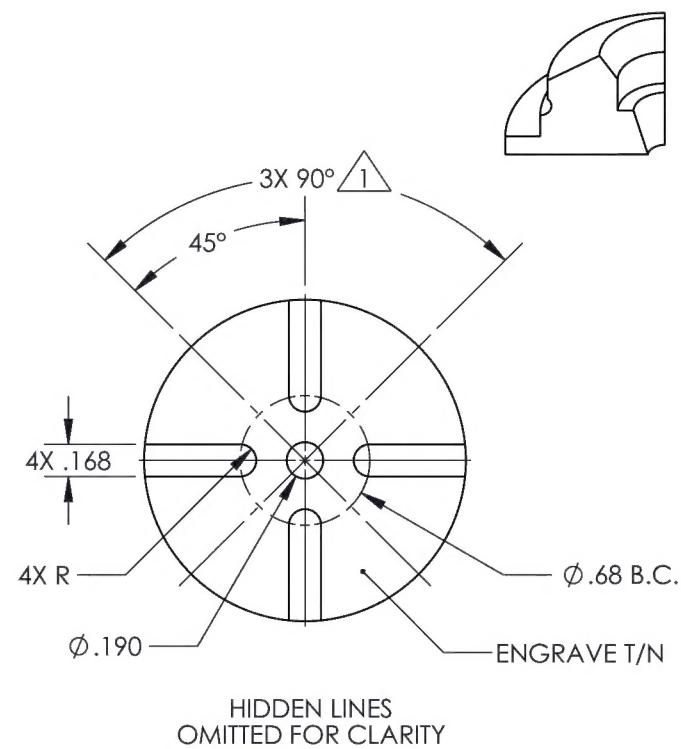
USED ON MODEL  
EC145

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REV		ECR		DESCRIPTION		DATE	INITIAL	APPROVED
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SECTION A-A



NOTE:

EDM TO SPLIT INTO 4 EQUAL PIECES.



STAKING TOOL

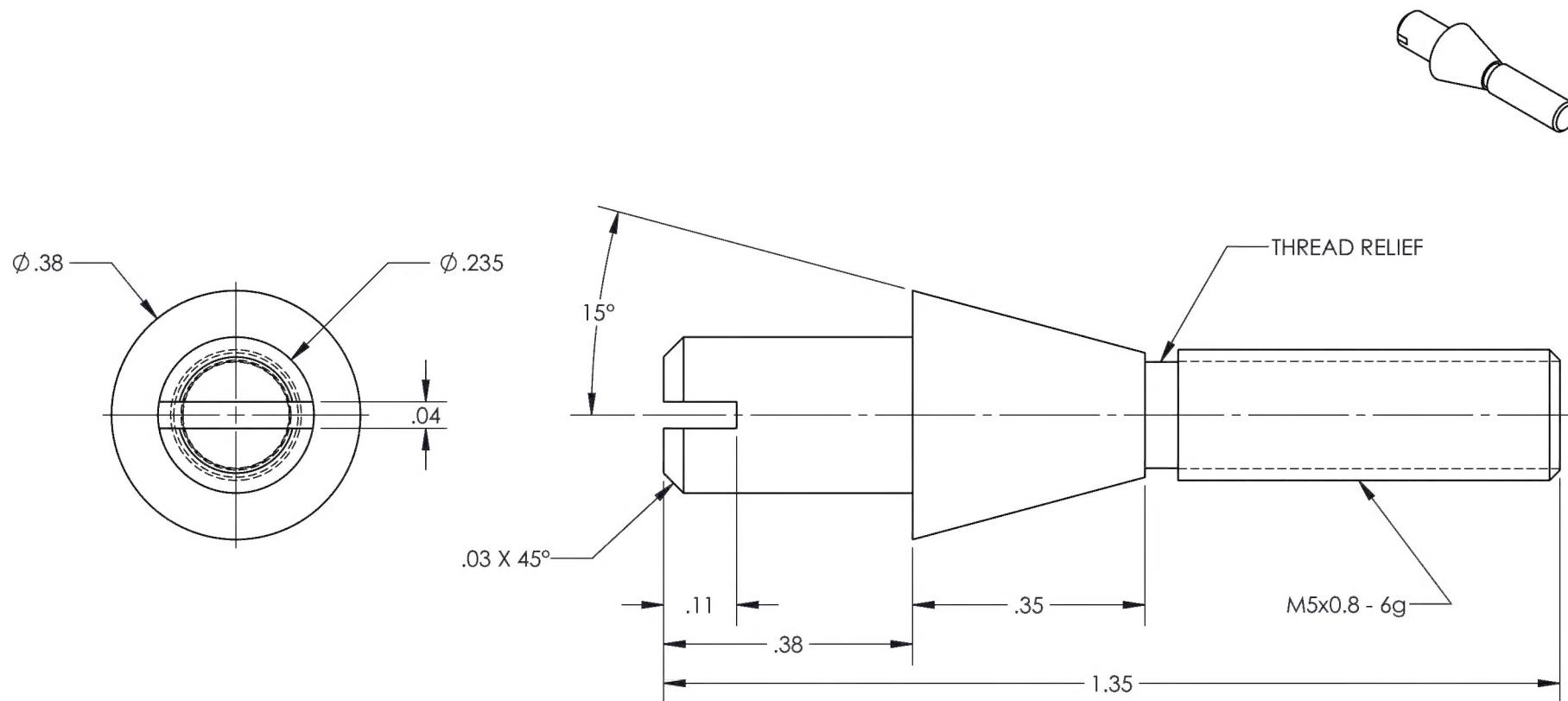
TITLE		REV
DWG NO.		1
RBE105-41069W3-3		
MATERIAL 4140/4142		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 50-55		.XXX ± .005 FRACTIONS ± 1/8
TREAT		.XX ± .01 ANGLES ± 5°
FINISH ZINC PLATE		X ± .1 SURFACES = 125
SPEC ASTM B633 TYPE I SC 2		✓
DRAWN BY: DUERFELDT		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY		USED ON MODEL
APPROVED: GILBERT		EC145
SCALE	1:1	DATE 1/19/2016
		SHEET 3 OF 4

(-3)

STAKING INSERT

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REV	ECR	REVISIONS		
		DESCRIPTION	DATE	INITIAL



(5)  
POSITIONING SCREW

	
TITLE	
DWG NO.	STAKING TOOL RBE105-41069W3-5
REV	1
MAT'L	4140/4142
HEAT	RC 48-55
TREAT	
FINISH	ZINC PLATE
SPEC	ASTM B633 TYPE I SC 2
DRAWN BY:	DUERFELDT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125 ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
EC145	
SCALE 4:1	DATE 1/19/2016
	SHEET 4 OF 4